



Dart Aerospace Ltd.
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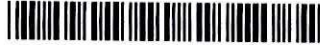
D4150-3
Job Sheet 180910



Part No: D4150-3

Job Qty: 10 ea

Part Name: Arm Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/17/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP Rev:A 10.06.24 new issue DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		7/31/18	0.00	0.00	Start Up Waterjet		<i>[Signature]</i>
100	Waterjet	10 pcs		7/31/18	0.00	0.66	Waterjet1		<i>[Signature]</i>
120	QC	10 pcs		7/31/18	0.00	0.00	QC8		38
150	Packaging	10 pcs		7/31/18	0.00	0.00	Packaging3	5+087	JUL 24 2018
160	QC21-SA	10 Ea		7/31/18	0.00	0.00	QC21		JUL 24 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	.2540 sf (.0254 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S11GA	0	12	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Arm Plate	0.191Inches + 0.005 - 0.001	0.196 0.190	0.195	Diameter
2	Arm Plate	0.257Inches + 0.006 - 0.001	0.263 0.256	0.262	Diameter
3	Arm Plate	1.000Inches ± 0.010	1.010 0.990	1.006	
4	Arm Plate	0.968Inches ± 0.010	0.978 0.958	0.970	
5	Arm Plate	0.375Inches ± 0.010	0.385 0.365	0.379	
6	Arm Plate	0.300Inches ± 0.010	0.310 0.290	0.304	
7	Arm Plate	0.800Inches ± 0.010	0.810 0.790	0.806	
8	Arm Plate	1.590Inches ± 0.030	1.620 1.560	1.594	
9	Arm Plate	2.340Inches ± 0.030	2.370	2.345	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		DISPOSITION				AGAINST DEPARTMENT/PROCESS						
Part No. _____		Rework				Cross tube			Water Jet		Engineering	
NCR No. _____		Scrap				Small Fab			Prod. Eng. Coord.		Quality	
		Use-as-is				Finishing			Rec/Store/Packaging		Other	
		Suspected Unapproved				Composite			Supplier			
Date: _____	Step #: _____	QTY Effective: _____										
Description Work Order Deviation												
Disposition: _____												
Completed By _____												
Lead hand / Supervisor Approval Verification _____												
QC / QA Coordinator Approval _____												
MARB (QS1042) Approval _____												



Container No: S093457
Part: D4150-3
Job No: 180910
Serial No/ Batch: S093457
Revision: _____
Inspector: _____
Exp Date: _____
Instructions: _____

Date: 07/18/18

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CANADA
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Root Cause											
Environment	No Re-verification	Pressu									
Design	Operator	Bending									
Doc/Data	Offset/Setup	Centre N									
Equip/Tooling	Supplier	Cracks									
Handling/Pre	Training	Crimp/Kin									
Material	Use for Testing	Cuffs									
Internal Transport	Poor Information	Crushing									
Tribal Knowledge	Rushing	Heat Treat									
LOA	Product Improvement	Wave/Twist i									
Substation	Process Improvement	Marks/Chatte									
Past Expiry Date	Manufacturing Process										
Misidentified	Past Due										
OTHER: _____											

Sequence											
Off-set											
Mislabeled											
Fit/Function											
Misaligned/off center											
Drill Holes											
Dimensions Incomplete/Unclear											
Part Lost/Missing											
Part Moved											
Drawing											
Finish											
Misread											
Turning Sequence											

			2.310	
10	Arm Plate	0.750Inches $\pm$ 0.030	0.780 0.720	0.755
11	Arm Plate	1.560Inches $\pm$ 0.030	1.590 1.530	1,568
12	Arm Plate	1.188Inches $\pm$ 0.010	1.198 1.178	1,180
13	Arm Plate	0.125Inches $\pm$ 0.010	0.135 0.115	0,116

Plex 7/17/18 2:54 PM Dart.lajeunesse.marie